

D205.633011

Work Order ID 61533



Page 1

Monday, August 30, 2010 10:19:46 AM

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 8/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-30 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 ✓

10.09.23

2-Deburr ends ✓

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

4

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

④ 10.09.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

Accept

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives of the project. These objectives should be clear, measurable, and achievable.

3. The third step is to develop a plan of action. This involves determining the steps that need to be taken to achieve the objectives and assigning responsibilities to team members.

4. The fourth step is to implement the plan. This involves carrying out the tasks and activities that have been planned.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and identifying any areas for improvement.

Setup Start

Stop

**Cust Item ID:**[illegible]

Customer:

Run Start

Stop

SPC (Y/N):

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Oty**

Reject
QtyReject
Number

**Insp.
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

[illegible]

10/05/24

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

Abstract

Memo

0.00

HandFinish

Hand Finishing

140

QC3- Inspect Part Finish

0.00

[illegible]

Memo

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 61533

Monday, August 30, 2010 10:19:46 AM



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Item ID:	D2563	Accept		Setup	Start	
Revision ID:						
Item Name:	Step Weldment Assembly				Stop	
Start Date:	8/30/2010	Start Qty:	4.00			
Required Date:	9/6/2010	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>M112260</u> Large Fab	0.00							
	Memo	0.00							
	1-Inspect for foreign object per QSI 024								
	2-Weld Remainig End cap as per Dwg D2563 using DT 8343								
	3-Grind								
160 QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
	Quality Control								
170 QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

10.09.27

10.09.27

10.09.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 61533

Monday, August 30, 2010 10:19:46 AM



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Item ID: D2563	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Step Weldment Assembly					
Start Date: 8/30/2010	Start Qty: 4.00		Cust Item ID:		
Required Date: 9/6/2010	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M115091 START TIME: 1:00 OVEN TEMPERATURE: 8200 FINISH TIME: 1:30	0.00 0.00				④	φ		
190 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M11508 Memo	0.00 0.00				⊕	φ		
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

BL 10-9-28

BL 10-9-28

all 10/09/29

PO 10/9/30 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 61533

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Start Date: 8/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 4.00

**



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP
61534

0.00

Packaging

10/10/10 (y)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/10 (y)

MF
10-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 10:19:50 AM

Page 1

Work Order ID: 61533

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00


Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116  Step Extrusion		Manufactured	No			100	Each	121.0000	1	4			
--	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--


Location	Loc Qty	Loc Code
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WA	121	
57850	35	
60307	86	

D2561  Lug		Manufactured	No			100	Each	3.0000	2	8			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--


Location	Loc Qty	Loc Code
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WA	3	
60096	3	
59685		

D2564  Mounting Angle		Manufactured	No			100	Each	27.0000	2	8			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	27	
59686	7	
60097	20	

D2673-34  End Plate		Manufactured	No			100	Each	178.0000	1	4			
--	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	178	
57527	1	
59690	177	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 10:19:50 AM

Page 2

Work Order ID: 61533



Parent Item: D2563



Parent Item Name: Step Weldment Assembly

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

150

Each

178.0000

1

4



End Plate

OK 10.09.22

Location

Loc Qty

Loc Code

WA

178

57527

1

59690

177

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

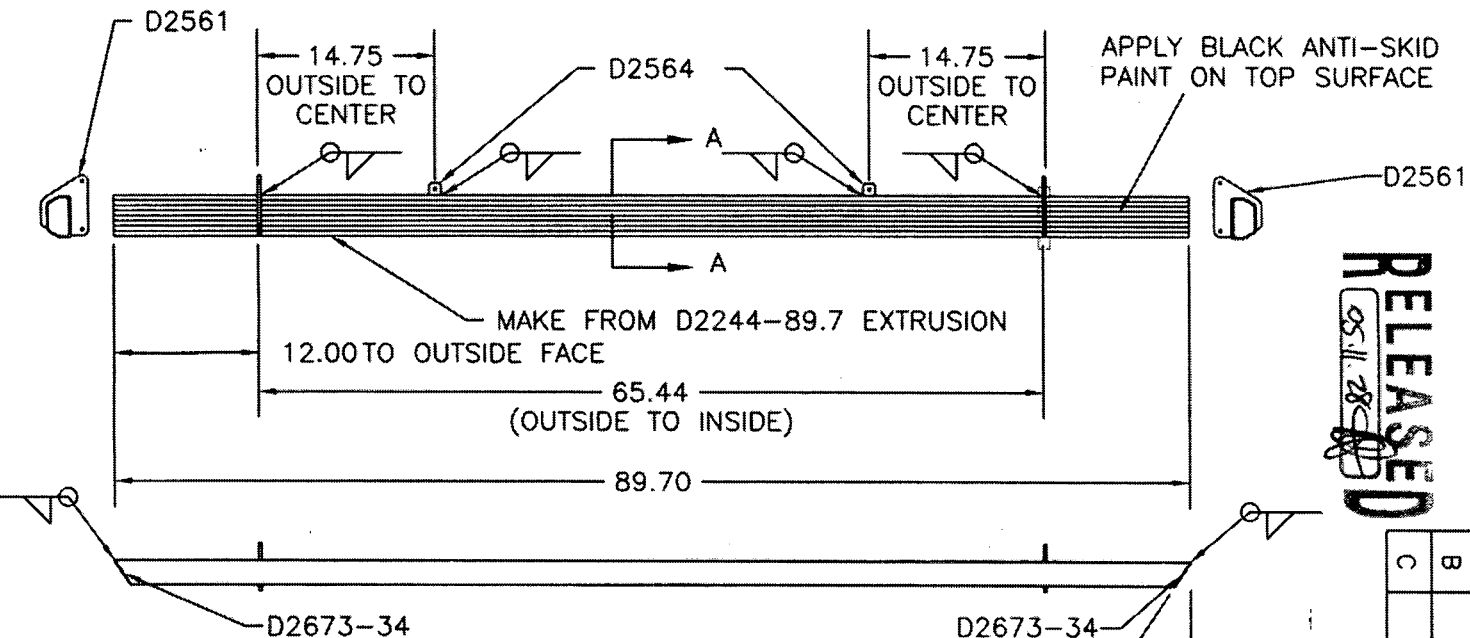
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

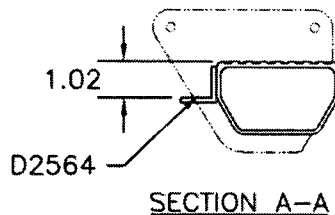
RELEASED
05.11.28-10



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



SECTION A-A

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
BW	44	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		D2563	SCALE
05.11.14		STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41533
05-10-83

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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